

IN THE CLAIMS:

The following is a complete listing of claims in this application.

Claims 1-14 (canceled).

15. (currently amended) Powder product for the protection of centrifugal casting molds used for the manufacture of cast iron pipes, comprising a mixture of:

at least one inoculating alloy;

at least one strongly reducing metal that is volatile at the temperature of liquid cast iron, the at least one strongly reducing metal being in the form of at least one non-ferrous alloy; and

optionally inert mineral powder.

16. (previously presented) Product according to claim 15, wherein the at least one inoculating alloy comprises a mixture of a plurality of inoculating alloys.

Claims 17-18 (canceled).

19. (currently amended) ~~Product according to claim 18,~~
Powder product for the protection of centrifugal casting molds used for the manufacture of cast iron pipes, comprising a mixture of:

at least one inoculating alloy;

at least one strongly reducing metal that is volatile at the temperature of liquid cast iron; and

optionally inert mineral powder,

wherein the at least one strongly reducing metal ~~is~~
comprises magnesium or calcium present in an amount of between 0.5 and 2% by weight of the powder product.

20. (previously presented) Product according to claim 15, wherein the at least one strongly reducing metal comprises 0.3 to 18% by weight of the product.

Claim 21 (canceled).

22. (currently amended) Product according to claim ~~21~~ 15, wherein the at least one non-ferrous alloy contains less than 10% by weight of Fe.

23. (previously presented) Product according to claim 22, wherein the at least one non-ferrous alloy is an SiCa alloy containing, by weight:

Si 58 - 65%; Ca 27 - 35%; Fe 2 - 7%; Al 0.4 - 2%.

24. (currently amended) Product according to claim ~~22~~ 23, containing between 15 and 40% by weight of said SiCa alloy.

Claim 25 (canceled).

26. (currently amended) ~~Product according to claim 15,~~
Powder product for the protection of centrifugal casting molds
used for the manufacture of cast iron pipes, comprising a
mixture of:

at least one inoculating alloy;

at least one strongly reducing metal that is volatile at
the temperature of liquid cast iron; and

~~containing~~ between 0.2 and 15% by weight of ~~said~~ an inert mineral powder.

27. (currently amended) Product according to claim ~~25~~ 26, wherein the inert mineral powder is selected from the group consisting of calcium fluoride, magnesium fluoride and mixtures thereof.

28. (currently amended) Process for manufacturing a powder product for the protection of centrifugal casting molds used for the manufacture of cast iron pipes, comprising at least one inoculating alloy, at least one strongly reducing metal that is volatile at the temperature of liquid cast iron and inert mineral powder, comprising forming a powder premix of the at least one strongly reducing metal and the inert mineral powder, and mixing the powder premix with the at least one inoculating alloy in powder form.

wherein the at least one strongly reducing metal constitutes 15 to 60% by weight of the premix.

Claim 29 (canceled).

30. (new) In a process for molding cast iron comprising bringing molten cast iron into contact with an inside surface of a centrifugal casting mold,

the improvement comprising protecting the mold by applying to the inside surface a powder product comprising at least one inoculating alloy and at least one strongly reducing metal that is volatile at the temperature of the molten cast iron, before bringing the molten cast iron into contact with the inside surface of the mold.

31. (new) Process according to claim 30, wherein the at least one inoculating alloy comprises a mixture of a plurality of inoculating alloys.

32. (new) Process according to claim 30, wherein the at least one strongly reducing metal is an element in column FI of the periodic table of elements.

33. (new) Process according to claim 32, wherein the at least one strongly reducing metal is an element in subgroup IIa of the periodic table of elements.

34. (new) Process according to claim 33, wherein the at least one strongly reducing metal is magnesium or calcium.

35. (new) Process according to claim 30, wherein the at least one strongly reducing metal comprises 0.3 to 18% by weight of the product.

36. (new) Process according to claim 30, wherein the at least one strongly reducing metal is added in the form of at least one non-ferrous alloy.

37. (new) Process according to claim 36, wherein the at least one non-ferrous alloy contains less than 10% by weight of Fe.

38. (new) Process according to claim 37, wherein the at least one non-ferrous alloy is an SiCa alloy containing, by weight:

Si 58 - 65%; Ca 27 - 35%; Fe 2 - 7%; Al 0.4 - 2%.

39. (new) Process according to claim 38, wherein the product contains between 15 and 40% by weight of said SiCa alloy.

40. (new) Process according to claim 34, wherein the product contains between 0.5 and 2% by weight of magnesium.

41. (new) Process according to claim 30, wherein the product additionally comprises between 0.2 and 15% by weight of an inert mineral powder.

42. (new) Process according to claim 41, wherein the inert mineral powder is selected from the group consisting of calcium fluoride, magnesium fluoride and mixtures thereof.